

Work Order ID 87313

July-13-12 11:51:09 AM

87313

Page 1

Item ID: D4419-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Support Plate
 Start Date: 7/10/12 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4419	A

100		0.00							
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100
 Waterjet Memo 0.00

FLOW CNC Waterjet
 304.128
 1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC Memo 0.00

Quality Control

8 0 Jm 12-7-21
 8 0 Jm 12-7-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4419-3 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Aft Support Plate
Start Date: 7/10/12 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/17/12 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SMB 12-7-23	DAS 16 e-3	76422		8			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 ST 1/2				8x			SP 12-7-23
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							12/17/24 MR 12-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 87313

Parent Item: D4419-3

Start Date: 7/10/12

Required Date: 8/17/12

Parent Item Name: Aft Support Plate

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA
304/316 0.125 Sheet

Purchased No

sf 25.4260

~~29103158~~
30

Sm 12-7-12

Location

Loc Qty

Loc Code

MAT020

25.426

121380

13.6

121780

11.826

121380

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

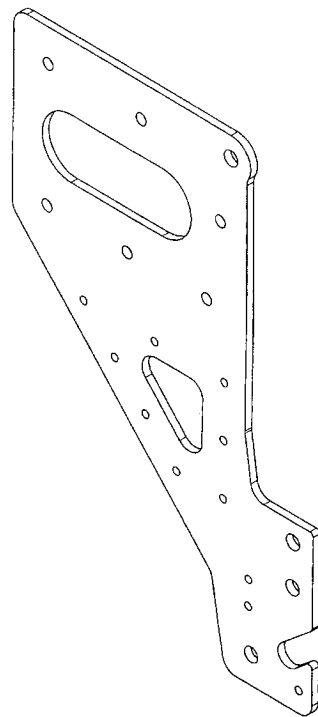
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	87313
Description: Aft Support Plate		Part Number:	D4419-3
Inspection Dwg: D4419 Rev: A		Page 1 of 2	

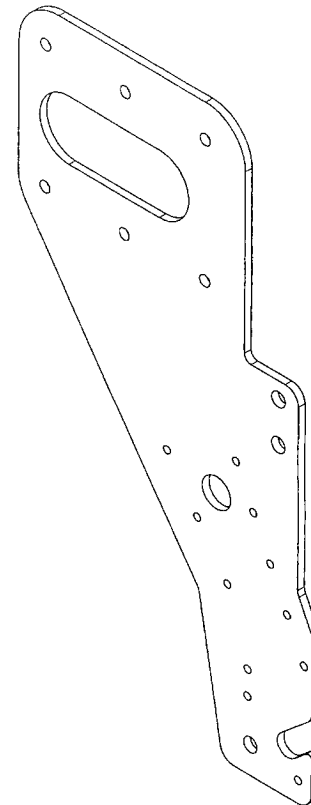
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	✓		✓	mmol
Ø0.191	+0.005/-0.001	0.191"	✓		✓	"
Ø0.250	+0.005/-0.001	0.250"	✓		✓	"
Ø0.53	+0.008/-0.001	0.530"	✓		✓	"
5.55	+/-0.030	5.562"	✓		✓	"
5.27	+/-0.030	5.281"	✓		✓	"
4.25	+/-0.030	5.267"	✓		✓	"
2.80	+/-0.030	2.797"	✓		✓	"
0.40	+/-0.030	0.406"	✓		✓	"
3.83	+/-0.030	3.833"	✓		✓	"
5.56	+/-0.030	5.578"	✓		✓	"
6.26	+/-0.030	6.273"	✓		✓	"
7.14	+/-0.030	7.151"	✓		✓	"
7.73	+/-0.030	7.737"	✓		✓	"
0.31	+/-0.030	0.316"	✓		✓	"
0.38	+/-0.030	0.385"	✓		✓	"
0.750	+/-0.010	0.754"	✓		✓	"
1.53	+/-0.030	1.539"	✓		✓	"
0.390	+/-0.010	0.386"	✓		✓	"
0.450	+/-0.010	0.457"	✓		✓	"
1.67	+/-0.030	1.675"	✓		✓	"
10.55	+/-0.030	10.557"	✓		✓	Prodwsor
8.00	+/-0.030	8.005"	✓		✓	mmol
6.02	+/-0.030	6.024"	✓		✓	"
1.10	+/-0.030	1.093"	✓		✓	"
1.20	+/-0.030	1.212"	✓		✓	"
0.50	+/-0.030	0.495"	✓		✓	"
1.500	+/-0.010	1.505"	✓		✓	"
0.60	+/-0.030	0.610"	✓		✓	"
2.300	+/-0.010	2.307"	✓		✓	"
0.63	+/-0.030	0.641"	✓		✓	"
0.991	+/-0.010	0.995"	✓		✓	"
0.440	+/-0.010	0.446"	✓		✓	"

10



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

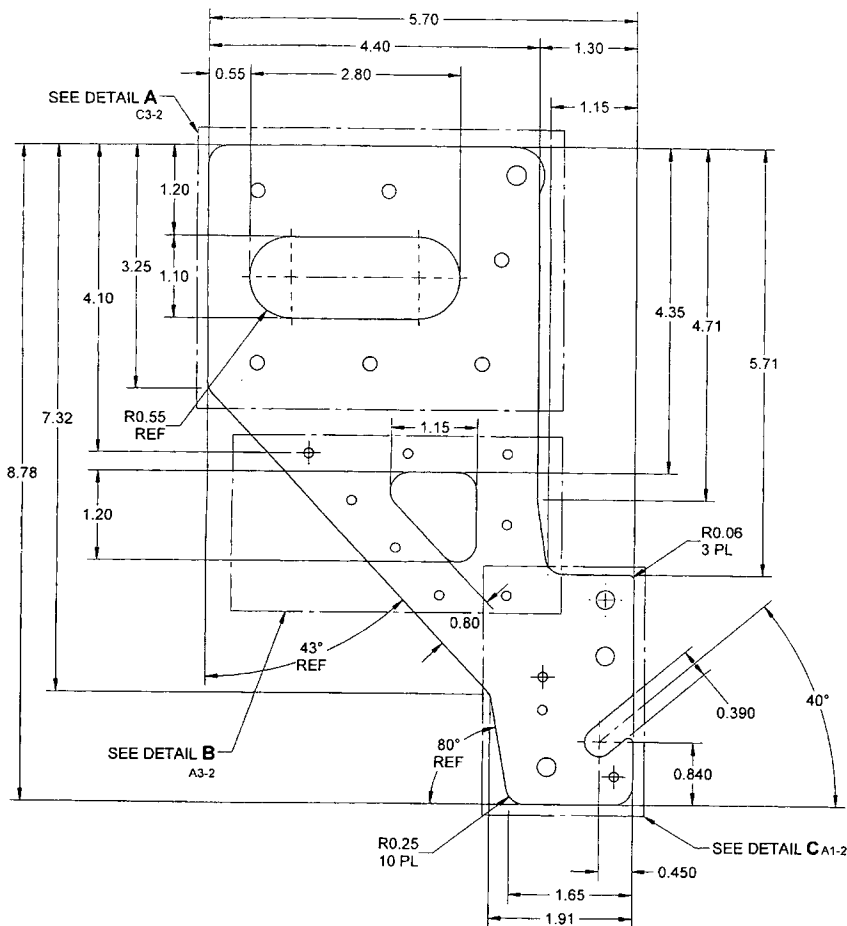
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87313 MCT
12/07/13

RELEASED
2011-07-28
MM

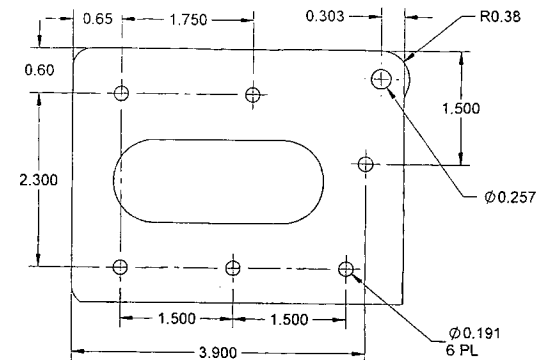
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

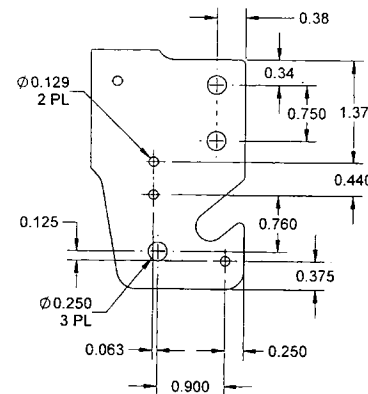
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REV.		DESCRIPTION			BY		DATE	
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MFG. APPR.		<i>EE</i>		D4419		SHEET 1 OF 3		
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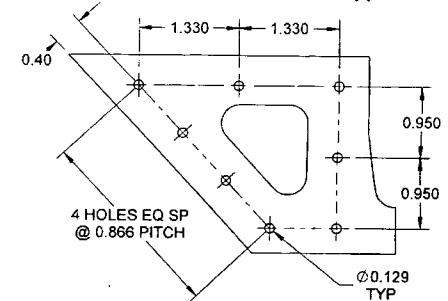
D4419-1 FWD SUPPORT PLATE



DETAIL A D8-2



DETAIL B B7-2

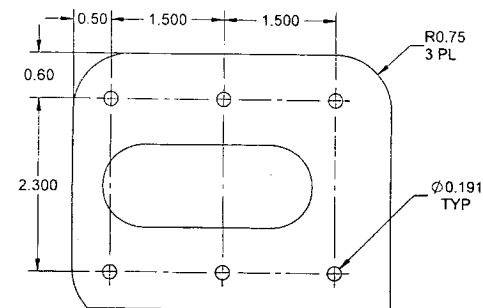
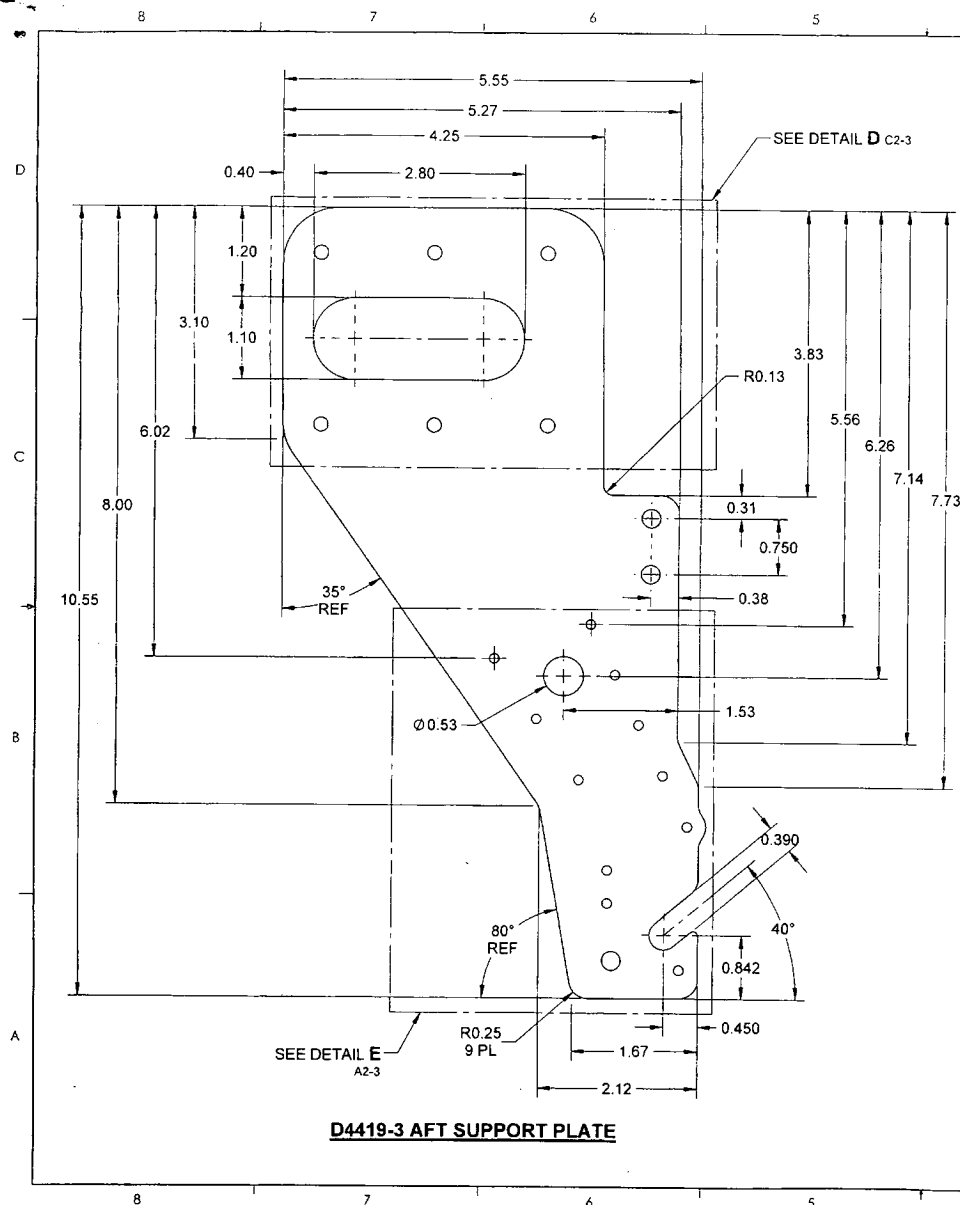


DETAIL C A4-2

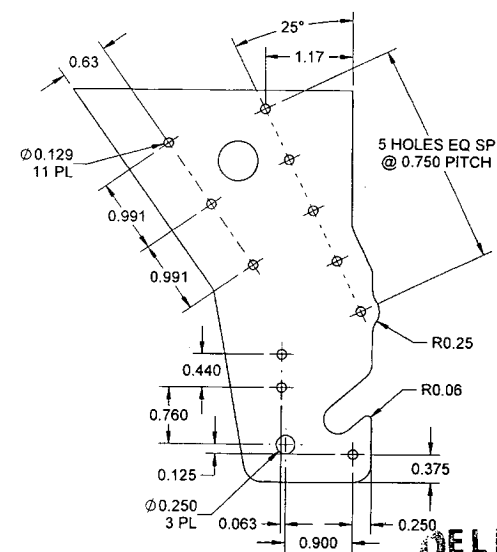
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RELEASED
R 2011-07-28
W



DETAIL D D5-3



DETAIL E A7-3

RELEASED
2011-11-18
JAN

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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